

Work Order ID 102469

102469

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May-29-13 3:22:25 PM

Item ID: D3875-1

Accept

N900040100

Setup

Start

NS1

Revision ID:

Item Name: Floor Protector

Stop

NS2

Start Date: 5/29/13 Start Qty: 1.00 *1*

Cust Item ID:

Required Date: 6/03/13 Req'd Qty: 1.00 *1*

Customer:

Reference:

Approvals:	Process Plan:	ML5	Date: 13-05-30	Tooling:	Date:	Run	Start	*NR1*
	QC:		Date:	SPC (Y/N):	Date:		Stop	*NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr								
D3875	Rev B	0.00							
100									
100									
HandThermo	Memo	0.00							
Hand Finishing Thermoforming	1-Cut Sheet to required Blank size								

DAS
07
8:00
13/06/04

105

105

HandThermo

Hand Finishing Thermoforming

Dry Material

Memo

Dry Sheet as per OSI022 POLYCARBONATE
Temp: 240^oF

Time IN: 7:00 am 13/06/03

Time OUT: 6:00 am 13/06/04

x2

DAS
07
8:00
13/06/04

W/O: 102469

WORK ORDER CHANGES

DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
13/06/04	110						

Part No: D3875-1

PAR #: _____

Fault Category: Thermodynamic

NCR: Yes No DQA:

Date: 13/06/04

Resolution: Scram

Disposition: SCRAP

QA: N/C Closed:

Date: 13/06/04

WORK ORDER NON-CONFORMANCE (NCR)								
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
13/06/04	110	Insect flew onto Mould & trapped in part. P.C. Shop Doors were left open when forming / heat	DAS 16 9-04 Q2042 13/06/04	Scrap & Replace part.	Wb- 13/06/04	DAS 21 9-04 13/06/04	DAS 16 9-04 Q2042 13/06/04	DAS 16 9-04 13/06/04

NOTE: Date & initial all entries

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Item ID: D3875-1**Accept*****N900040100*****Setup Start*****NS1*****Revision ID:****Item Name:** Floor Protector**Stop*****NS2*****Start Date:** 5/29/13 **Start Qty:** 1.00 ***1*****Cust Item ID:****Required Date:** 6/03/13 **Req'd Qty:** 1.00 ***1*****Customer:****Reference:****Approvals:** **Process Plan:****Date:****Tooling:****Date:****Run Start*****NR1*****QC:****Date:****SPC (Y/N):****Date:****Stop*****NR2*****Sequence ID/
Work Center ID****Operation
Description****Set Up/
Run Hours****Tool ID****Tool #****Plan
Code****Accept
Qty****Reject
Qty****Reject
Number****Insp.
Stamp**

165

165

QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Shops
218
B.G.B

1

170

170

Packaging

Packaging

Identify as per dwg & Stock Location: _____

0.00

PPP 162296.

K

Sp
13-6-13

180

180

QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

0.00

13/6/17 JJ

M 13-06-13

Picklist Print

May-28-13 10:20:58 AM

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Work Order ID: 102469

Parent Item: D3875-1

Parent Item Name: Floor Protector

Start Date: 5/29/13

Required Date: 6/03/13

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev. A 09.02.06 New Issue DL
Material 10/04/21 DL

IPP Rev.B Add Step 105 Dry

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MLEXS.118-90318-08		Purchased	No			100	sf	477.9500	9.84	9.84			Sh

Lexan Sheet

Location	Loc Qty	Loc Code
therm	477.95	
113127	477.95	

19.68 sq ft.

13/06/10.

DQA: _____ Date: _____

Date:



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Date:

Work Order update only

Work Order Update Only				Work Order Update Only									
Work Order: _____ Part No. _____ NCR No. _____				DISPOSITION			AGAINST DEPARTMENT/PROCESS						
				Rework	Skid-tube	Crosstube	Water Jet	Engineering					
				Scrap	Machining	Small Fab	Prod. Eng. Coor.	Quality					
				Use-as-is	Thermoforming	Finishing	Rec/Store/Packaging	Other					
				Suspected Unapproved	Large Fab	Composite	Supplier						
Root Cause		Date	Step	Qty	Description of work order update or non-conformance		Initial Chief Eng	Action Description		Sign & Date	Verification	QC Inspector	
Design													
Doc/Data													
Equip/Tooling													
Handling/Pre													
Material													
Operator													
Offset/Setup													
Process													
Supplier													
Training													
Transport													
Unapproved													
FAULT CATEGORY													
Landing Gear				General									
				Bending	Bend	Folio/Program	Outside Dimensions	Pressure/Forced					
Centre Not Concentric	BOM/Route	Grain	Over/Under tolerance	Set-up									
Cracks	Broken/Damage/Defect	Hardware	Part Incorrect	Temperature/Cure									
Crimp/Kink/Ripple/Wave	Burrs	Inspection Incomplete/Unqualified	Part Lost/Missing	Weld									
Cuffs	Contamination	Instructions Incomplete/Unclear	Part Moved	Wrong Stock Pulled									
Crushing	Countersink	Misaligned/off center	Positioned Wrong										
Heat Treat	Cut Too Short	Mislabeled	Power Loss/Surge										
Inspection Strip in Tube	Drawing	Misread											
Marks/Chatter	Drill Holes	Off-set											
Turning Sequence	Finish	Out of Calibration											
Wave/Twist in Tube	Fit/Function	Out of Sequence											

DART AEROSPACE LTD	Work Order:	102469
Description: Floor Protector	Part Number:	D3875-1
Inspection Dwg: D3875	Rev: B	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

THERMOFORMING SECTION

Description	Accept	Reject	Method of Inspection	Comments
Inside Radii less than <u>3/16</u> "	✓			
Shape Definition	✓			
Texture Retention	✓			
Material imperfections such as bumps, cracks, voids, scratching	✓			

Measured by:

W.H.

Date:

18/04/04

TRIMMING SECTION

Measured by:

Dh - 30

Date:

13/04/10

Audited by:

20

Date:

15 (a) 13

Preliminary Approval:

Date: _____

Rev	Date	Change	Revised by	Approved
A	09.09.15	New Issue	KJ	
B	13.05.08	Dimensions updated per Dwg Rev B	KJ	

